

Covered Electrodes

KBH-2

For hardfacing (High Cr, Hv 300)

Description

- Hardfacing of roller and shear used at elevated temperature, ingot tongs and forged metal mould.
- The deposited weld metal has the microstructure of carbide precipitation in the austenite matrix.
- Preheat at about 150°C and maintain the interpass temperature above 150°C for multilayer welding of low alloy steels and high carbon steel.
- Redry the electrode at 70~120°C for 30~60 minutes prior to use.

Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Mo	W
0.29	0.15	1.25	0.015	0.012	8.2	16.4	45.0	5.4

Typical mechanical properties of all-weld metal

Conditions	As welded	
	Continuous surfacing	Interpass temp. max. 150°C
HV	250	320
HRC	22.2	32.2
HS	36	45

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	3.2	4.0	5.0
Length	(mm)	350	400	400
Amp. (A)	F	100~120	120~150	150~180